



Dart Aerospace Ltd.
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Canada

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D5445-041
Job Sheet 187863



Part No: D5445-041

Job Qty: 2 ea

Part Name: Longitudinal Beam Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/18/18

Job Tracking No:

Due Date: 1/25/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV C SHEETS 1,4 IPP REV:A NEW ISSUE 16-07-07 JLM VERIFIED BY:DD IPP REV:B 17.01.10 AS PER DWG REV.C DD VERF:JLM IPP REV:C 17.11.15 REVISE AS PER INTUITIVE INSTRUCTION DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		1/25/19	0.00	0.00	Start Up Skid tubes		MGC
100	CNC Bend Skid tubes	2 pcs		1/25/19	0.00	2.00	CNC Bend Skid tube		
110	QC	2 pcs		1/25/19	0.00	0.00	QC25		
120	Mill Conv	2 pcs		1/25/19	0.00	2.00	Conv Mill 1		
130	QC	2 pcs		1/25/19	0.00	0.00	QC2		
140	QC	2 pcs		1/25/19	0.00	0.00	QC8		
150	HandFinish	2 pcs		1/25/19	0.00	1.00	HandFinish1		
160	QC	2 pcs		1/25/19	0.00	0.00	QC7		
170	Small Fab	2 pcs		1/25/19	0.00	1.33	Small Fab		
180	QC	2 pcs		1/25/19	0.00	0.00	QC5		
184	Skid tubes	2 pcs		1/25/19	0.00	1.00	Skid tubes-3		
186	QC	2 pcs		1/25/19	0.00	0.00	QC5		
190	Powdercoat	2 pcs		1/25/19	0.00	0.40	Powdercoat1		
200	QC	2 pcs		1/25/19	0.00	0.00	QC3		
210	HandFinish	2 pcs		1/25/19	0.00	1.00	HandFinish4		
220	QC	2 pcs		1/25/19	0.00	0.00	QC5		
230	Packaging	2 pcs		1/25/19	0.00	0.00			
240	QC21-SA	2 Ea		1/25/19	0.00	0.00	QC21		

Part Op 100 - BEND/CUT AS PER DWG

Descriptions: 120 - -MILL/DRILL/C'SINK AS PER DWG. -Insure proper orientation -DEBURR

170 - INSTALL NUT PLATES AS PER DWG

184 - 1- Pick (4) D4720-1 space for each beams and chemical convert them. 2- Swage x-bolt spacers as per dwg. Trim off access material as required. 3- After swaging, ream x-spacer hole if necessary to finish size. 4- Touch up alodine after swaging. 5-INSTALL END CAPS

190 - ***MASK NUT PLATE HOLES*** START TIME: 10:00 OVEN TEMPERATURE: 320° FINISH TIME:

210 - SEAL END CAPS WITH SIKAFLEX AS PER NOTE 11

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6TR1.5X1.0W125	6061-T6 Rect Tube 1.5 X 1.0 X .125W	12 ft (6 ea)	90-Start up Operation	S100232
CR2672-3-(03)	Cherry Rivet	16 Ea (8 ea)	170-Small Fab	S141242
MS21059-4	Nut Plate	6 Ea (3 ea)	170-Small Fab	S065256
MS21061L4	Nutplate	2 Ea (1 ea)	170-Small Fab	S065257
D4720-1	Spacer	8 Ea (4 ea)	184-Skidtubes	S030687
D5445-043	End Cap Assembly	4 Ea (2 ea)	184-Skidtubes	B158775
MS24694-S3	Screw	8 Ea (4 ea)	184-Skidtubes	S094431

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6TR1.5X1.0W125	12	24	0
170-Small Fab	CR2672-3-(03)	16	12	0
	MS21059-4	6	52	0
	MS21061L4	2	42	0
184-Skidtubes	D4720-1	8	120	0
	D5445-043	4	12	0
	MS24694-S3	8	107	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE

Container No: S138575



Part: D5445-041

Job No: 187863

Serial No/Batch: S138575

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Plex 12/18/18 8:41 AM dart.white.jesse

Date: 12/18/18

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

DART AEROSPACE LTD		Work Order: 187863
Description: Longitudinal Beam Assy. LH		Part Number: 0.5445-041
Inspection Dwg: Saeen P/N Rev: C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
62.8	± 0.10	62.800	/		Tape	
0.60 (2PL)	± 0.02	0.600	/		Womens WDS	
0.177	$+0.005 -0.001$	0.178	/		"	
0.320 x 100°	$+0.006 -0.001$	0.325	/		"	
1.00 REF	± 0.03	0.998	/		"	
1.50 REF	"	1.496	/		"	
0.13 REF	"	0.127	/		"	
54.63	"	54.625	/		"	
1.50	"	1.500	/		"	
1.000	± 0.010	1.000	/		"	
4.97	± 0.03	4.970	/		"	
0.500	± 0.010	0.500	/		"	
1.200	"	1.200	/		"	
0.850	"	0.850	/		"	
0.300	"	0.300	/		"	
0.600	"	0.600	/		"	
0.375 (4PL)	$+0.006 -0.001$	0.378	/		"	
0.266	"	0.267	/		"	
0.098	$+0.004 -0.001$	0.098	/		"	
0.179 x 100°	$+0.005 -0.001$	0.182	/		"	
0.250	± 0.010	0.250	/		"	
0.500	"	0.500	/		"	
1.000	"	1.000	/		"	
0.312	"	0.312	/		"	
2.05	$+0.10 -0.05$	2.090	/		Tape	
1.3	± 2	1.3	/		Tape	

Measured by: [Signature]	Checked by: [Signature]	QC Inspector:
Date: 19/11/23	Date: 19/10/24	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	